

Date: Tuesday, 4/18/2006 10:02:39 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 26671	
Estimate Number : 11376	
P.O. Number : N/A	Part Number : D33872
This Issue : 4/18/2006 S.O. No. : N/A	Drawing Number : D3387 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 26162	Material : N/A
Written By : <u>See Comment Below</u>	Due Date : 5/2/2006
Checked & Approved By : <u>06.04.18</u>	Qty: 10 Um: Each
Comment : Est:A 05.06.10 New Issue KJ/JLM Est:B 06.03.22 Split c'sink op. EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
<div> </div> <p>Comment: Qty.: 1.5680 f(s)/Unit Total : 15.6797 f(s) 6061-T6 Bar .50" x 6.0" Material: 6061-T6/T651 (QQ-A-200/8) (M6061T6B0.500x06.000) Identify for D3387-2 Batch: <u>M100317</u></p> <p style="text-align: right;"><u>ml 06/04/29</u> 10</p>		
2.0	BAND SAW	BAND SAW
<div> </div> <p>Comment: BAND SAW Cut blank: 6.000" x 0.500" x 17.800" long</p> <p style="text-align: right;"><u>ml 06/04/29</u> 10</p>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
<div> </div> <p>Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA512 and Dwg D3387 Identify as D3387-2 Tumble and Deburr NO sharp edges</p> <p style="text-align: right;"><u>ml 06/04/29</u> 10</p>		
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
<div> </div> <p>Comment: CONVENTIONAL MILLING MACHINE C'sink Ø0.375" as per Dwg D3387</p> <p style="text-align: right;"><u>ml 06/04/29</u> 10</p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/05/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

TRK 06/04/27 10

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SP 06/04/30 10

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA30*

RE. 06-05-1

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/05/01 (10)

Job Completion



u 06-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	26671
Description: Arm		Part Number:	D3387-2
Inspection Dwg: D3387 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	0.501	—			
7.577	+/-0.010	7.581	—			
R0.030	+/-0.010	R0.030	—			
Ø0.191	+0.005/-0.000	Ø0.191	—			
1.700	+/-0.010	1.701	—			
0.188	+/-0.010	0.190	—			
11.405	+/-0.010	11.405	—			
Ø0.507	+0.000/-0.001	Ø0.5066	—			
2.033	+/-0.005	2.033	—			
R0.300	+/-0.010	R0.300	—			
1.000	+/-0.005	1.000	—			
2.000	+/-0.010	2.000	—			
1.347	+/-0.005	1.347	—			
0.250	+/-0.010	0.251	—			
R0.125	+/-0.010	R0.125	—			
0.125	+/-0.010	0.132	—			
R0.032	+/-0.010	R0.032	—			
Ø0.375 x100°	+/-0.010	Ø0.375x100	—			
0.500	+/-0.010	0.493	—			
0.300	+/-0.010	0.298				

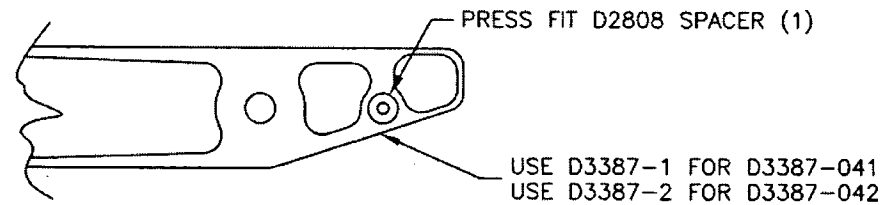
Measured by:	<i>ML</i>	Audited by:	<i>EP</i>	Prototype Approval:	N/A
Date:	06/04/29	Date:	06/04/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM <i>AK</i>	<i>SM</i>

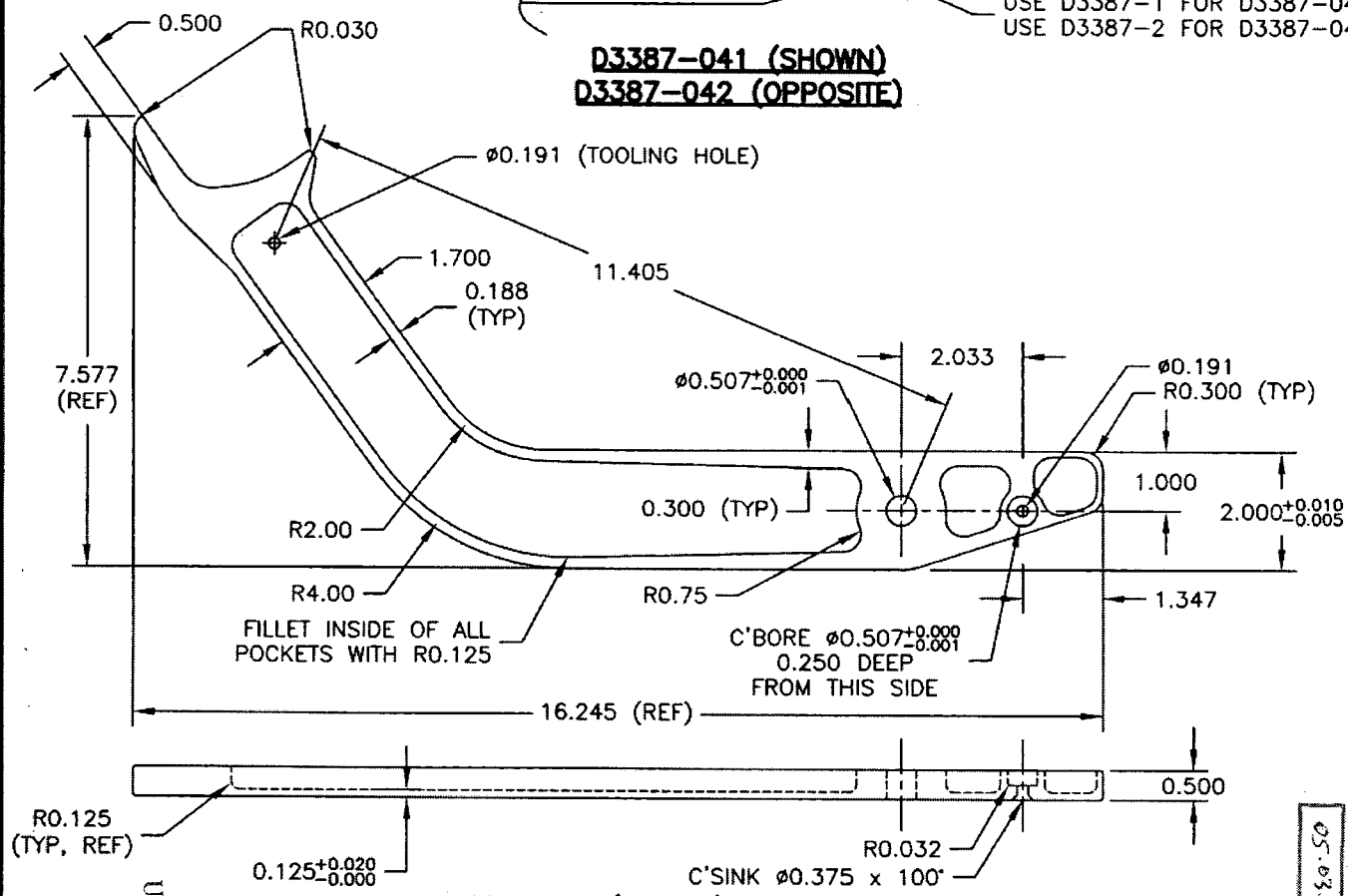


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3387	REV. A
DATE 05.01.18	TITLE ARM	SHEET 1 OF 1	
A	05.01.18	NEW ISSUE	SCALE 1:3

RELEASED
05.03.11



D3387-041 (SHOWN)
D3387-042 (OPPOSITE)



D3387-1 (SHOWN)
D3387-2 (OPPOSITE)

GENERAL NOTES

- 1) MACHINE PER DRAWING FILE "D3387-A.DWG"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11) 0.500 THICK (REF DART SPEC. M6061T6B0.500)
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26671